Work Orde Thursday, Novem	r ID 63604 ber 04, 2010 1:00:	32 PM										Page 1
	D3245-3		A	Accept					Setup	Start		
Revision ID: Item Name:	Door		.1				,			Stop		
Start Date: 1 Required Date: 1 Reference:		t Qty: 6.00 d Qty: 6.00	18418 111 1881 18418 111 1881		Cust Item Customer:							
Approvals:	Process Plan:	H	Date: 10-11-04	Tooling:	D	ate:			Run	Start		
	QC:		_ Date:	SPC (Y/N):	D	ate:				Stop		
Sequence ID/ Work Center ID	Oper: Descr	ation iption	-	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision N	lbr					-	,				
D3245	Rev B											
Waterjet FLOW CNC Waterjet		WATER JET Memo 1-Cut as pe Deburr if no	r Dwg D3245 □Dwg Rev: ecessary	0.00 0.00 CProg Rev:	<u>B</u> □2-				0-11-	18_		
110	QC2- I	nspect parts off r	nachine FAI/FAIB	0.00								
QC Quality Control		Memo		0.00			. •	B	10-11-	-18		man and an other contracts
	QC8- I	inspect parts - sec	ond check	0,00	∖⁄i&	A SHE		#; (Ho				
QC Quality Control		Memo		0.00	- ((O		s.	100	ノ —			

Duitho	ospace	Ltu								× .
W/O:			WC	RK ORDER CHANG	ES		****		+ .	· · ·
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Y	es N	o DQ	4 :	Date:	
		esolution:	Disposition	າ:	QA: N/C	Clo	sed:	*	Date:	
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (N	CR)			-	
DATE	CTED	Description of NC	Corrective Action		tion B		Verific	ation		Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Secti		Chief Eng	QC Inspector
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	1 1						1			

Work Order ID 63604

Thursday, November 04, 2010 1:00:32 PM



Page 2

Item ID:

D3245-3

Accept

Setup Start

Stop



Revision 19:

Start Date:

Item Name: Door

Required Date: 11/15/2010

11/4/2010

Start Qty: 6.00

Req'd Qty: 6.00



Cust Item ID: Customer:

Reference:

A	nn	ro	va	ls:	
	มม		v a	13.	

Process Plan: _____

Date:

Tooling:

Date: Date:

Start Run



Date:_____

SPC (Y/N):

Set Up/

Run Hours

Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

Work Center ID 130

Brake NC

Sequence ID/

Brake NC

NC BRAKE

Operation

Description

0.00

0.00

Deburr if necessary, buff entire surface to ensure a nice surface finish.

Form

D3245-3 as per Dwg D3245 □ Identify as D3245-3

QC

Quality Control

QC5- Inspect part completeness to step on W/O

150

Identify as per dwg & Stock Location: 233

0.00

Memo

Memo

0.00

Packaging Packaging

OSPACE L								
		W	ORK ORDER CHAN	GES				Ť.
STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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1	PAR #:	Fault Cate	gory:	NCR: Yes	_ Date: _			
Resc	olution:	Dispositio	n:	QA: N/C (Closed:		Date: _	
	A	WORK ORD	ER NON-CONFORM	IANCE (NC	R)			
STED	Description of NC				Verifi	cation	Approval	Approval
SILF	Section A	Initial Chief Eng	Action Description Chief Eng		& Sect		Chief Eng	QC Inspector
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	STEP	STEP PRO PRO PAR #: Resolution: Description of NC	STEP PROCEDURE CHA PAR #: Fault Cate Resolution: Disposition WORK ORD STEP Description of NC Section A Initial	WORK ORDER CHANGE PROCEDURE CHANGE PAR #: Fault Category: Resolution: Disposition: WORK ORDER NON-CONFORM STEP Description of NC Section A Corrective Action Section A Corrective Action Description	STEP PROCEDURE CHANGE By PAR #: Fault Category: NCR: Yes Resolution: Disposition: QA: N/C C WORK ORDER NON-CONFORMANCE (NC STEP Description of NC Section A Section B Initial Action Description Sign	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date :PAR #:Fault Category:NCR: Yes No DQ Resolution:Disposition:QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng/Prod Mgr

Work Order ID 63604

Thursday, November 04, 2010 1:00:32 PM



Page 3

Item ID:

D3245-3

Accept

Setup Start

Stop

Start



Revision ID:

Start Date:

Item Name: Door

Required Date: 11/15/2010

11/4/2010

Start Qty: 6.00

Req'd Qty: 6.00

Operation

Description

Cust Item ID: Customer:

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Accept

Qty

QC:

Memo

Date: SPC (Y/N): Date:

Tool # Plan

Code

Stop

Reject

Qty

Sequence ID/

Work Center ID

160

QC21- Final Inspection - Work Order Release

Set Up/ Run Hours

0.00

Reject

Number

Quality Control

0.00

11/01/12/4) Mr 11-01-12

Insp.

Stamp

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W/O:			W	ORK ORDER CHAN	IGES					ì					
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Part No		PAR #:													
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		Description of NC	Corrective Action				Verific	ation	Approval	Approval					
DATE	STEP	Section A	Initial Chief Eng	Action Descriptio Chief Eng	n	Sign & Date	Secti		Chief Eng	QC Inspector					
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							, `								

Picklist Print

Thursday, November 04, 2010 1:00:36 PM

Work Order ID: 63604

Parent Item: D3245-3

Parent Item Name Door



Start Date: 11/4/2010

Required Date: 11/15/2010

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP A□04.07.07□New issue□KJ/JLM□

IPP Rev:B Now on Waterjet 07-09-14 JLM Verified By:EC IPP Rev:c ECN 1052 07-10-31 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased	No			100	sf	85.5896	0.537	3.391579 [B) 510-11-	18	
					109023 109057	30.2	Oty 5896 2896 55.3	Loc Code	— Т	09057		6	

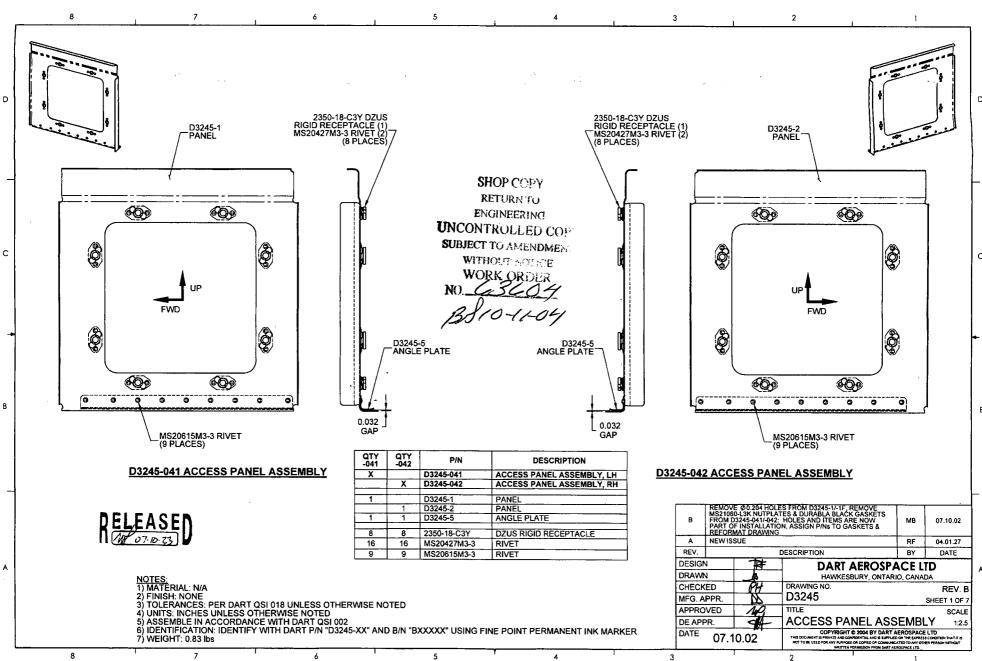
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DART AEROSPACE LTD	Work Order:	1,3604
Description: Door	Part Number:	D3245-3
Inspection Dwg: D3245 Rev: B		Page 1 of 1

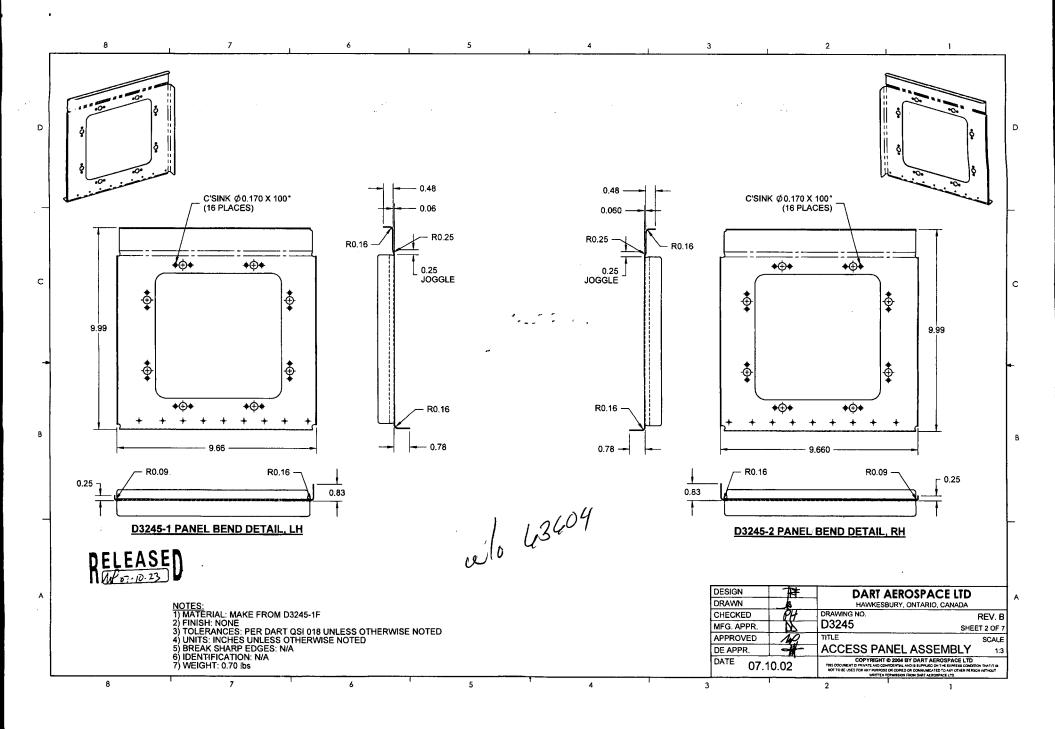
FIRST ARTICLE INSPECTION CHECKLIST

FIRST ARTICLE INSPECTION CHECKLIST											
:	x	First Arti	cle	Prote	otype						
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments				
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0.859	+/-0.010	278.	%		V						
2.609	+/-0.010	2.659	%		V						
3.500	+/-0.010	3,500	₽		V						
8.718	+/-0.010	8.719	S 22		V PRO 1802						
2.609	+/-0.010	2,608	&		V						
3.500	+/-0.010	3.499	*		V						
8.718	+/-0.010	8.724	×		V PRO PBO2						
1.220	+/-0.010	1.215	¥		V						
0.032	+/-0.010	EO.	X		V						
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:											
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Measured by:	B 1	Audited by:	2		Prototype Appr	oval:	N/A				
	10-11-18	Date:	10/11/18		1	Date:	N/A				
Rev Date	Change					sed by	Approved				
9.04ن. A	New Issue				KJ/D	D of	N				

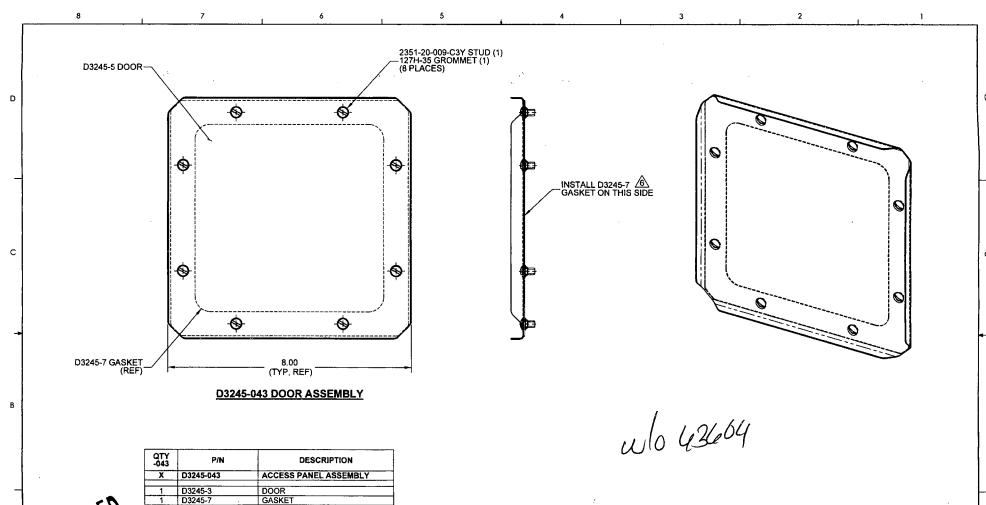
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DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
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QTY -043	P/N	DESCRIPTION
X	D3245-043	ACCESS PANEL ASSEMBLY
1	D3245-3	DOOR
1	D3245-7	GASKET
8	2351-20-009-C3Y	STUD
8	127H-35	GROMMET

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S

INSTRUCTIONS
7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
9) WEIGHT: 0.73 lbs

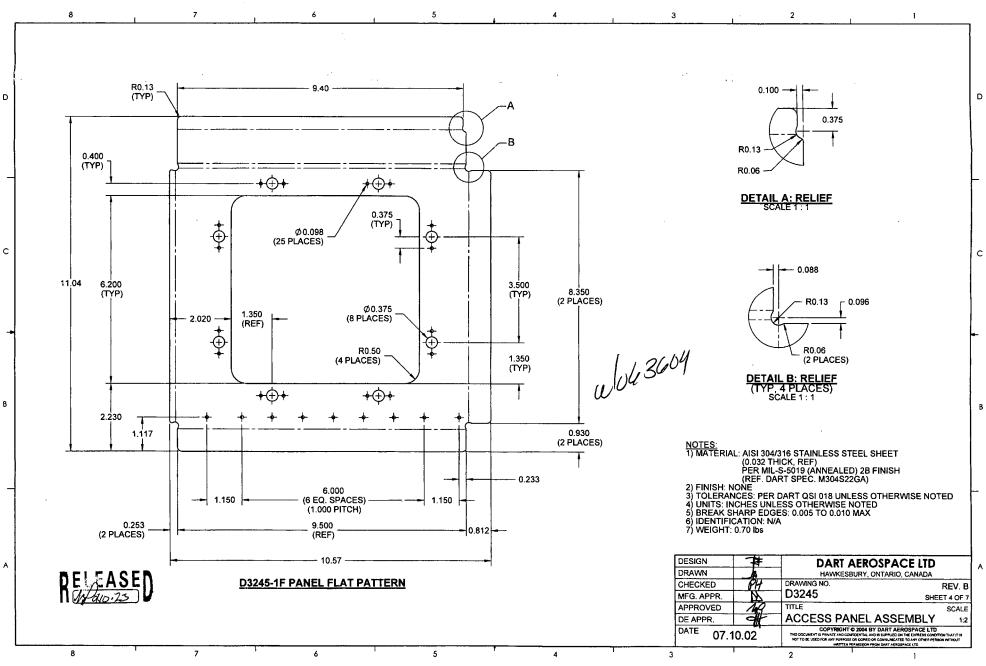
DESIGN	₩ Ŧ	DART AEROSPACE LTD
DRAWN	_A	. HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. REV. B
MFG. APPR.	NZ.	D3245 SHEET 3 OF 7
APPROVED	149	TITLE SCALE
DE APPR.	#	ACCESS PANEL ASSEMBLY 12
DATE 07.1	0.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD THE DODUMENT B PRINTE AND CONTIDENTIAL AND IS SUPPLED ON THE STREES CONSTRON THAT IT IS NOT TO BE USED FOR ANY DEPOSITION OF THE PROPERTY OF THE PROP

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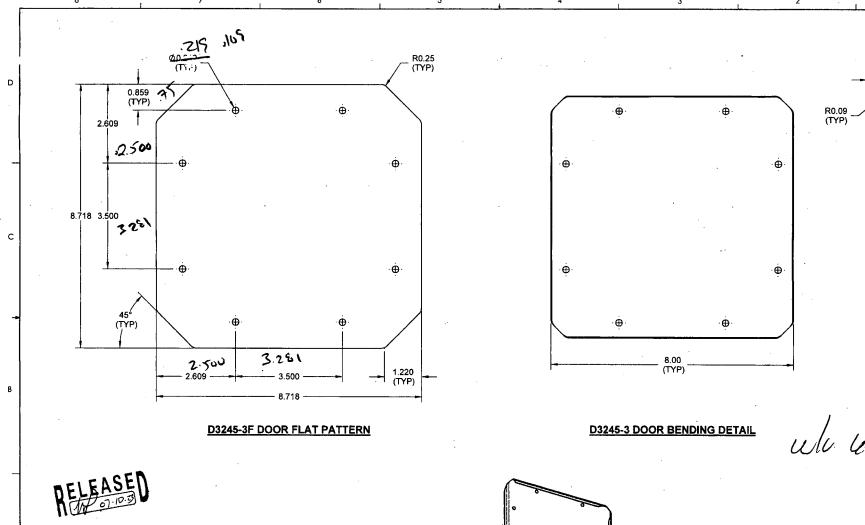
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		Description of NC	Corrective Action Section B			Verific	ation	Ammuovol	Approval
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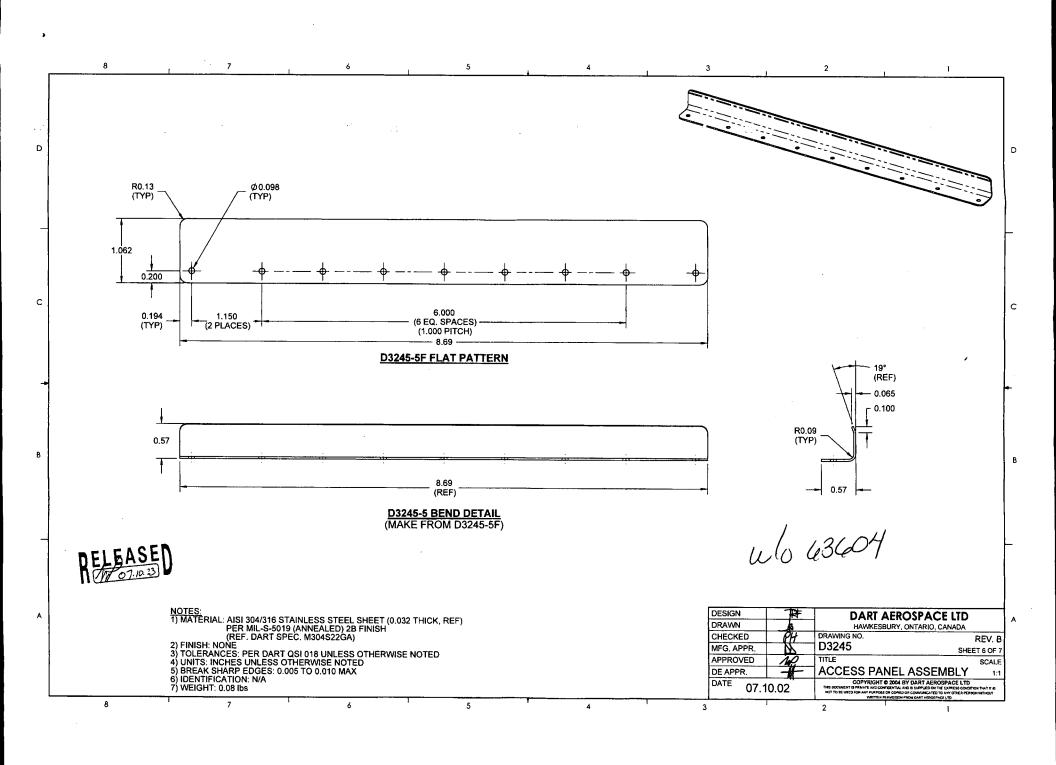
NOTES: 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.67 lbs

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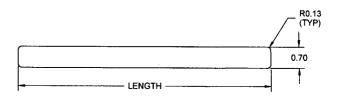
DESIGN	_ 1≱	DART AEROSPACE LTD					
DRAWN	_#	HAWKESBURY, ONTARIO, CANADA					
CHECKED	PH		EV. B				
MFG. APPR.	77	D3245 SHEET	5 OF 7				
APPROVED	149	TITLE	SCALE				
DE APPR.	4	ACCESS PANEL ASSEMBLY	1:2				
DATE 07.1	0.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDER THAN AND IS SUPPLIED ON THE EXPRESS CONCIDENT THAT IT IS NOT TO M. (RED DOOR AND A DESCRIPTION OF COMPUTED THAN AND ASSESSMENT OF THE PROPERTY METHOD.)					

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W/O:			W	ORK ORDER CHANG	ES				¢	
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R0.13 0.80 Ø0.325 (TYP) (TYP) (TYP) -ф-45° (REF) **-**Ф ф 7.80 (TYP) **.** ·(+) R0.50 (TYP) -⊕-2.150 (TYP) 3.500 (TYP) 0.400 0.34 (TYP) (TYP)



D3245-X GASKET

P/N	LENGTH	
D3245-9	8.35	
D3245-11	9.01	
D3245-13	9.50	

NOTES:
1) MATERIAL: DURABLA BLACK GASKET, 0.035 THICK
(PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)

D3245-7 GASKET

(PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3245 MFG. APPR. SHEET 7 OF 7 APPROVED TITLE ACCESS PANEL ASSEMBLY DE APPR. DATE COPYRIGHT © 2004 BY DART AEROSPACE LTD

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